| Work Ord October-07-13 | | B132 D407 | | *108 | 3132* | | | | 00 | t 18° | Page 1 |
|--|--------------------------|--|-----------------|----------------------|------------------------|--------|--------------|---------------|-------------------|------------------|----------------|
| Item ID: Revision ID: Item Name: | D4074-7 Striker Plate | В 100 | | Accept | *N900 | 0401 | INN |)* Se | etup Star Stop | 14 | S1* S2* |
| Start Date: Required Date Reference: | 10/02/13 : 10/07/13 | Start Qty: 12.00 Req'd Qty: 12.00 | *12* *12* | | Cust Item II Customer: | D: | | | | | |
| Approvals: | | n: MLJ | | | | ite: | | R | un Star Stoj | ``I \ I | R1* R2* |
| Sequence ID/ Work Center I | D | Operation Description | | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
| Draw Nbr | Rev | ision Nbr | | | | | | ~/ | • | | |
| D4074 | C | | | | | | | | | | |
| *1 \\ \n* Waterjet FLOW CNC Water | rjet | Memo 1-Cut as per | | 0.00 | | | | 12 | <u> </u> | | JMB-10-17 |
| 304.050 | | Dwg Rev: Prog Rev: 2-Deburr if r | <u>C</u> _ | | | | | | | | |
| *110 | | QC2- Inspect parts off m | achine FAI/FAIB | 0.00 | | | | 12 | ٥ | | JmB-10-1 |
| QC | | Memo | | 0.00 | | | | | | | |

Quality Control

| | | | | | | | | | | | DQA. | | • |
|---------------|--------------------------|-----------------|---------------------------------------|----------|--------|---|----------|---------|-------------------|-------------|---|---------------------------|--------------------|
| NCR: Y | ⁄es | / No | | | | WORK ORDER NON-C | 100 | NFOR1 | MANCE / UPD | PATE | QA Closed: | Date | : |
| Work Orde | er: | | | | | DISPOSITION | · | | | AGAINST DE | | | |
| Part N | • | | | | | Scrap Machining Small Fab Use-as-is Thermoforming Finishing Work Order Update Large Fab Composite | | | Finishing | 4 | Water Jet d. Eng. Coor. re/Packaging Supplier | Engineering Quality Other | |
| Root | T | | | | Descri | tion of work order update | 1 | nitial | Acti | on | Sign & | | |
| Cause | | Date | Step | Qty | 1 | or Non-conformance | | ief Eng | Descri | | Date | Verification | QC Inspector |
| Doc/Data | | | <u> </u> | | | | | | | | | | |
| Equip/Tooling | | | | | | | 1 | | | | | | |
| Operator | | | | | | | | | | | | | |
| Material | | | | | | | | | | | | | |
| Setup | | | | | | | | | | | | | |
| Other | | | | | | | | | | | | | |
| Process | | | | | | | | | | | | | |
| Supplier | | | i | | | | | | | | | | |
| Training | | | | | | | | | | | | | |
| Unapproved | | | | | | | | | | | | | <u>.</u> |
| | | ··· | · · · · · · · · · · · · · · · · · · · | | | F. | AUL | T CATE | GORY | | | | |
| Landi | ng G | Gear | | | _ | General | _ | | | _ | - | _ | _ |
| | Ш | Bending | | | | Bend | | Grain | | | Ovalized | | Pressure/Forced |
| | Ш | Centre No | ot Concei | ntric to | o/s | BOM/Route | L | Hardwa | re | | Over/Under | tolerance | Temperature/Cure |
| | - | Cracks | | | | Broken/Damaged | | 4 ' | on Incomplete | | Part Incorred | ct | Weld |
| | _ | Crushed/ | Crimped | `` | | Burrs | <u>_</u> | 4 | ions Incomplete/U | nclear | Part Lost/Mi | ssing | Wrong Stock Pulled |
| | - | Cuffs | | | | Contamination | <u></u> | Mainte | | | Part Moved | | |
| | Ш | Heat Trea | | | _ | Countersink | | Mislabe | eled | <u></u> | Positioned V | | ¬ |
| | Inspection Strip in Tube | | | | | Cut Too Short | Misread | | | Power Loss/ | Surge | Other | |
| | | Ripples in Bend | | | | Drill Holes | | Offset | | | | | |

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Brake NC

140

QC

Memo

0.00

OC5- Inspect part completeness to step on W/O

0.00

DAS 27 9-89

Memo

0.00 13 10.17

Quality Control

140

| NCR: Y | 'es | / No | | | | WORK ORDER NON-C | CONFOR | MANCE / UF | PDATE | DQA: | | · |
|--|-----|------|------|---------------------------------------|--------|----------------------------|---------------------|---|------------|---|---------------------------|--------------|
| Work Orde | · · | | | · · · · · · · · · · · · · · · · · · · | | DISPOSITION | | | AGAINST DE | QA Closed: PARTMENT | | |
| Part No. Skid-tube Skid-tube Machining Use-as-is NCR No. Work Order Update Large Fab | | | | | | | Machining noforming | Crosstube Small Fab Finishing Composite | 1 | Water Jet d. Eng. Coor. re/Packaging Supplier | Engineering Quality Other | |
| Root | | | | | Descri | ption of work order update | Initial | A | ction | Sign & | | |
| Cause | - 1 | Date | Step | Qty | C | or Non-conformance | Chief Eng | Des | cription | Date | Verification | QC Inspector |
| Doc/Data | | | | | | | | | | | | |
| Equip/Tooling | | | | | | | ļ | | | | | |
| Operator | | | | | | | | | | | | |
| Material [| | | | | | | | | | | | |
| Setup | | | [| | | | | | | 1 | | |

FAULT CATEGORY Landing Gear General Bend Ovalized Pressure/Forced Bending Grain Centre Not Concentric to O/S BOM/Route Over/Under tolerance Temperature/Cure Hardware Broken/Damaged Part Incorrect Inspection Incomplete Cracks Weld Crushed/Crimped Burrs Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled Cuffs Contamination Maintenance Part Moved Countersink Positioned Wrong Heat Treat Mislabeled Inspection Strip in Tube Cut Too Short Misread Power Loss/Surge Other Ripples in Bend Drill Holes Offset Torque Waves in Extrusion Drawing Out of Calibration Turning Sequence Finish Out of Sequence Wave/Twist in Tube Folio Outside Dimensions

Other
Process
Supplier
Training
Unapproved

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

October-07-13 9:12:13 AM

| October-07-13 | 9.12.13 AW | | | | | | | | | | | |
|--|---------------------------------------|---|---------------------------|----------------------|---------------------------|------------|--------------|---------------|------------|-------------------|------------------|------------------------|
| Item ID: Revision ID: | D4074-7 | | | Accept | *N900 | 040 | 100 | * s | etup | Start Stop | 14 | S1* |
| Item Name: Start Date: Required Date: Reference: | Striker Plate 10/02/13 10/07/13 | Start Qty: 12.00 Req'd Qty: 12.00 | *12* *12* | | Cust Item II Customer: | D: | | | | | *N; | S2* |
| Approvals: | | nn: | | | | te: | | R | un | Start Stop | *N | R1* |
| | QC: | | Date: | SPC (Y/N): | Da | te: | | | | • | *N | R2* |
| Sequence ID/ Work Center II | D | Operation Description | | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Rej Qty | | Reject Number | Insp. Stamp |
| *170 *170* Packaging | | Identify as per dwg & Sto | ock Location: <u>5709</u> | 0.00 | | | | 12 x | | DAS 28 9-89 | 13-10 | -2) |
| 180 *180* QC Quality Control | | QC21- Final Inspection - | Work Order Release | 0.00 | | | A) | J&m |) | 13/10 | /21. | F ₁₀ -2 |

| | | * | > |
|------|-------|---|---|
| DQA: | Date: | | |
| • | | | |

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

| | 23 / 110 | | | | | | J | | · | QA Closed: | Dat | e: |
|--------------|---------------|------------|------------|--------|--------------------------------|--------|---------|------------------------|------------------------|--------------|--------------------------|--------------------|
| Work Orde | ř. | | | | DISPOSITION | | | | AGAINST DE | PARTMENT | /PROCESS | |
| Part N | | | - | | Rework Scrap | | N | Skid-tube Machining | Crosstube Small Fab | Pro | Engineering Quality | |
| NCR N | 0 | | | | Use-as-is Work Order Update | | | oforming Large Fab | Finishing Composite | Rec/Stor | re/Packaging Supplier | Other |
| Root | | | | Descri | ption of work order update | Initi | ial | Act | tion | Sign & | | |
| Cause | Date | Step | Qty | • | or Non-conformance | Chief | Eng | Descr | ription | Date | Verification | n QC Inspector |
| Doc/Data | | | | | | | | | | | | |
| quip/Tooling | | | | | | | | | | | | |
| Operator | | | | | | | | | | | | |
| Material | | | | | | | : | | | | | |
| Setup | | | | | | | | | | | | |
| Other | | | | | | | | 1 | | | } | |
| Process | | | | | | | | 1 | | | | |
| Supplier | | | | | | | | | | | | |
| Fraining | | | | | | | | l | | | į. | |
| Jnapproved | | | | | | | | | | | | |
| | | | | | | AULT C | ATE | SORY | | | | |
| Landin | g Gear | | | | General | _ | | | | _ | | |
| | Bending | | | _ | Bend | ☐ Gr | ain | | | Ovalized | | Pressure/Forced |
| | Centre No | ot Conce | ntric to (| o/s | BOM/Route | На | rdwa | re | | Over/Under | tolerance | Temperature/Cure |
| | Cracks | | | | Broken/Damaged | Ins | pecti | on Incomplete | | Part Incorre | ct | Weld |
| | Crushed/ | Crimped | | | Burrs | Ins | tructi | ions Incomplete/U | Unclear | Part Lost/Mi | issing | Wrong Stock Pulled |
| L | Cuffs | | | | Contamination | м | ainte | nance | | Part Moved | | |
| | Heat Trea | at | | | Countersink | Mi | slabe | led | | Positioned V | Vrong | |
| | Inspectio | n Strip in | Tube | | Cut Too Short | Шмі | sread | I | | Power Loss/ | 'Surge | Other |
| [| Ripples in | Bend | | | Drill Holes | Off | fset | | | | | |
| [| Torque V | aves in l | Extrusion | n [| Drawing | Ou | ıt of C | Calibration | | | | |
| | Turning S | equence | | | Finish | Ou | it of S | Sequence | | | | |
| | Wave/Tw | ist in Tul | эe | | Folio | Ou | ıtside | Dimensions | | | | |

Picklist Print

October-07-13 9:12:13 AM

Work Order ID:

108132

Parent Item:

D4074-7

Parent Item Name:

Striker Plate

Start Date: 10/02/13

Required Date: 10/07/13

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP Rev:A 10.06.08 new issue DD verf:EC

IPP REV:B AS PER ECN 11-613

| | 11-07-25 JLM VE | RIFIED BY:EC | | | | | | | | | | | |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|-------------------------------|---------------|----------------|---------|
| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
| M304S18GA 304/316 .050 Sheet | | Purchased | No | | | 100 | sf | 361.0374 | 0.0103 | 0.1301 052 〇.みs | 2 S | Jm. | 3-10-12 |
| | | | | Location | | Loc Qty | <u>Lo</u> | oc Code | | | | | |
| | | | | MAT019 | | 173.45001 | | | | | | | |
| | | | | 117 | 7188 | 3.88 | | | | | | | |
| | | | | 117 | 7766 | 5 | | | | | | | |
| | | | | 120 | 0604 | 5 | | | | | | | |
| | | | | 12: | 2325 | 3 | | | | | | | |
| | | | | 12. | 3155 | 3 | | | | | | | |
| | | | | 124 | 1572 | 0.00001 | | | | | | | |
| | | | | Mi | 26647 | 153.57 | | | | | | | |
| | | | | MAT020 | | 187.58742 | | | | | | | |
| | | | | 129 | 0243 | 0.928 | | | | | | | |
| | | | | 12 | 1626 | 1.529894 | | | | | | | |
| | | | | 12- | 4029 | 84.046526 | | | | | | | |
| | | | | M | 126098 | 101.083 | | | 26 | <u>లా క</u> | | | |

| NCR: Y | es / No | | | | WORK ORDER NON-C | DQA: | Date: |). | | | |
|---------------|----------|------|-----|--------|--|-----------|--------------|------------|--|---------------------|---------------|
| WCK. | es / 140 | | | | WORK ORDER NON-C | | VIAIVEL / OF | DATE | QA Closed: | Date: | |
| Work Orde | r: | | | | DISPOSITION | | Skid tubo | AGAINST DE | PARTMENT, | /PROCESS Water Jet | Engineering |
| Part N | | , | | | Rework Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Work Order Update Large Fab Composite | | | | Prod. Eng. Coor. Rec/Store/Packaging Supplier | | Quality Other |
| Root | | | | Descri | ption of work order update | Initial | Ad | ction | Sign & | | |
| Cause | Date | Step | Qty | | or Non-conformance | Chief Eng | Desc | cription | Date | Verification | QC Inspector |
| Doc/Data | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | |
| Operator | |] | | | | | | | | | |
| Material | ļ | ł | | | | | | | | | |
| Setup | | | | | | | | | | | |
| Other | | | | | | | | | | | |
| Process | | | | | | | | | | | |
| Supplier | | | | | | | | | | | |
| Training | | | | | | | | | | | |

| Landing | Gear | General | _ | | _ | _ |
|---------|------------------------------|----------------|---------------------------------|---|----------------------|--------------------|
| | Bending | Bend | Grain | | Ovalized | Pressure/Forced |
| | Centre Not Concentric to O/S | BOM/Route | Hardware | | Over/Under tolerance | Temperature/Cure |
| | Cracks | Broken/Damaged | Inspection Incomplete | | Part Incorrect | Weld |
| | Crushed/Crimped | Burrs | Instructions Incomplete/Unclear | | Part Lost/Missing | Wrong Stock Pulled |
| | Cuffs | Contamination | Maintenance | | Part Moved | - |
| | Heat Treat | Countersink | Mislabeled | Г | Positioned Wrong | _ |
| | Inspection Strip in Tube | Cut Too Short | Misread | | Power Loss/Surge | Other |
| | Ripples in Bend | Drill Holes | Offset | | _ | |
| | Torque Waves in Extrusion | Drawing | Out of Calibration | | | |
| | Turning Sequence | Finish | Out of Sequence | | | |
| | Wave/Twist in Tube | Folio | Outside Dimensions | | | |

FAULT CATEGORY

Unapproved

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

| DART AEROSPACE LTD | Work Order: | 10813/ |
|------------------------------|--------------|-------------|
| Description: Striker Plate | Part Number: | D4074-7 |
| Inspection Dwg: D4074 Rev: C | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|----------------------|-----------|---------------------|--------|--------|-------------------------|----------|
| 0.75 | +/-0.030 | 0.754 | _ | | V | Temos |
| 1.43 | +/-0.030 | 1.428" | | | V | |
| 0.26 | +/-0.030 | 0.267 | | | U | |
| 3.60 | +/-0.030 | 3.603" | - | | U | |
| 1.17 | +/-0.030 | 1.179 | - | | U | |
| 2.10 | +/-0.030 | 2.108 | - | | U | |
| 0.050 | +/-0.010 | 0.048 | | | V | |
| | | | | | | |
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| | | | DAS | | | |

| | | 27 | | |
|-----------------|-------------|-------|-----------------------|--|
| Measured by: Jm | Audited by: | 9-89 | Preliminary Approval: | |
| Date: 13-10-12 | Date: | RIOIS | Date: | |
| | 1 1 | | | |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|----------------------------------|------------|----------|
| A | 10.10.25 | New Issue | KJ | |
| B | | 2.10 was 1.72 per Dwg Rev B | KJ 1 | Al- |
| C | 11.11.07 | Dimensions updated per Dwg Rev C | KJ OW | <u> </u> |



